



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 75807**

October-31-11 12:39:34 PM

**\*75807\***

Page 2

**Item ID:** D3238-1

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

**Revision ID:**

**Item Name:** Plate

Stop

**\*NS2\***

**Start Date:** 31/10/2011 **Start Qty:** 12.00

**\*12\***

**Cust Item ID:**

**Required Date:** 09/11/2011 **Req'd Qty:** 12.00

**\*12\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**Tooling:** \_\_\_\_\_

**Date:** \_\_\_\_\_

Run

Start

**\*NR1\***

**QC:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**SPC (Y/N):** \_\_\_\_\_

**Date:** \_\_\_\_\_

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

130

**\*130\***

Waterjet

FLOW WATER JET

0.00

*B11-11-7*

FLOW CNC Waterjet

**Memo**

0.00

140

**\*140\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

*B11-11-7*

**Memo**

0.00

150

**\*150\***

QC

Quality Control

QC8- Inspect parts - second check

0.00

*8/11/11 07*

*(+18)*

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**Work Order ID 75807**

October-31-11 12:39:34 PM

**\*75807\***

Page 3

**Item ID:** D3238-1

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

**Revision ID:**

**Item Name:** Plate

Stop

**\*NS2\***

**Start Date:** 31/10/2011 **Start Qty:** 12.00

**\*12\***

**Cust Item ID:**

**Required Date:** 09/11/2011 **Req'd Qty:** 12.00

**\*12\***

**Customer:**

**Reference:**

<b>Approvals:</b>	<b>Process Plan:</b> _____	<b>Date:</b> _____	<b>Tooling:</b> _____	<b>Date:</b> _____	<b>Run</b>	<b>Start</b>	<b>*NR1*</b>
	<b>QC:</b> _____	<b>Date:</b> _____	<b>SPC (Y/N):</b> _____	<b>Date:</b> _____	<b>Stop</b>		<b>*NR2*</b>

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
160 <b>*160*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				18	SL	11-11-8	
	<b>Memo</b>	0.00							
170 <b>*170*</b> QC	QC3- Inspect Part Finish	0.00							
	<b>Memo</b>	0.00							
180 <b>*180*</b> Packaging	Identify as per dwg & Stock Location: <i>042</i>	0.00							
	<b>Memo</b>	0.00							

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 75807**

October-31-11 12:39:34 PM

**\*75807\***

Page 4

Item ID: D3238-1

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Plate

Stop

**\*NS2\***

Start Date: 31/10/2011 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 09/11/2011 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*1Q0\***

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

October-31-11 12:39:38 PM

Page 1

Work Order ID: 75807

\*75807\*

Parent Item: D3238-1

\*D3238-1\*

Parent Item Name: Plate

Start Date: 31/10/2011

Required Date: 09/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-10-20 EC  
IPP Rev:B Now on Waterjet 07-01-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	208.8000	0.012	0.151579			,

\*M2024T3S 080\*

2024-T3 .080 sheet

Location	Loc Qty	Loc Code
MAT022	208.8	
105411	6	
109424	4	
110347	0.5	
112331	3	
113796	7	
114025	15.7	
116604	5.8	
117392	40.1	
118180	49.7	
119117	77	119117

,5

1B11-3

1B11-11-7 1B

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	75807
Description: Plate	Part Number:	D3238-1
Inspection Dwg: D3238	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-11-7	Date:	W/W/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.10.17	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

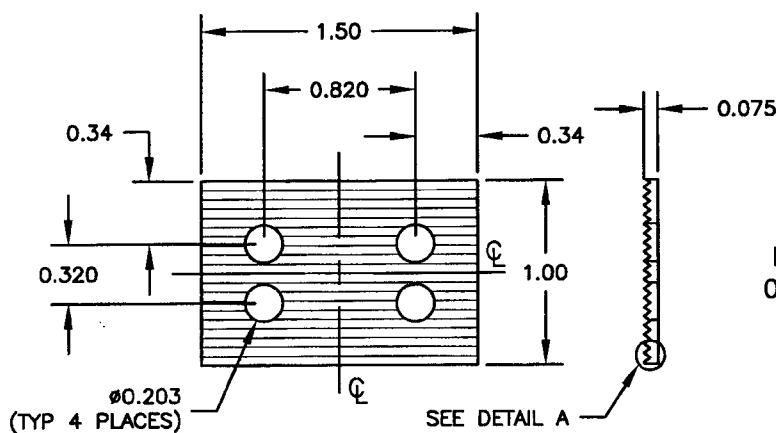
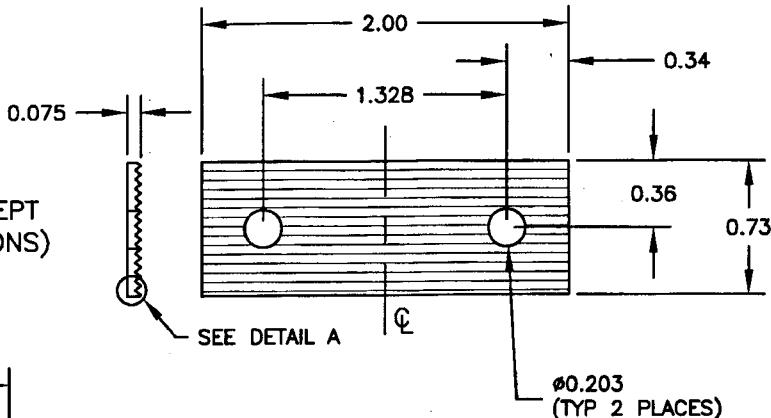
**DART**

DESIGN <i>#</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3238
DATE 07.02.19	TITLE PLATE	REV. C SHEET 1 OF 3 SCALE 1:1
A	03.11.25	NEW ISSUE
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6
C	07.02.19	ADD 5052-H32 OPTION

RELEASED

07.02.20 *CH*

**D3238-1 PLATE (SHOWN)**  
 D3238-11 PLATE (SAME, EXCEPT  
 0.020 THICK AND NO SERRATIONS)



**D3238-3 PLATE (SHOWN)**  
 D3238-13 PLATE (SAME, EXCEPT  
 0.020 THICK AND NO SERRATIONS)

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 35807 M.L.J  
 11/10/31

**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
 ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
 (REF DART SPEC M2024T3S)
- 11/-13/-15/-31/-33/-35 PLATE:  
 ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
 AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
 OR  
 ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
 AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT  $\frac{1}{4}$

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

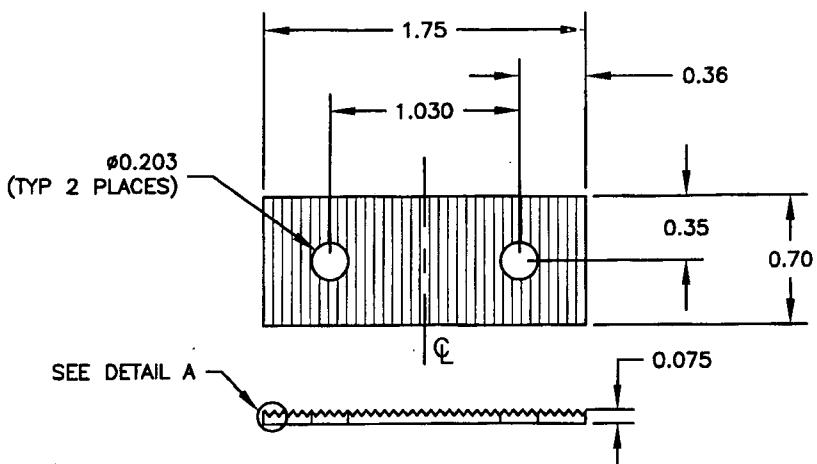
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**DART**

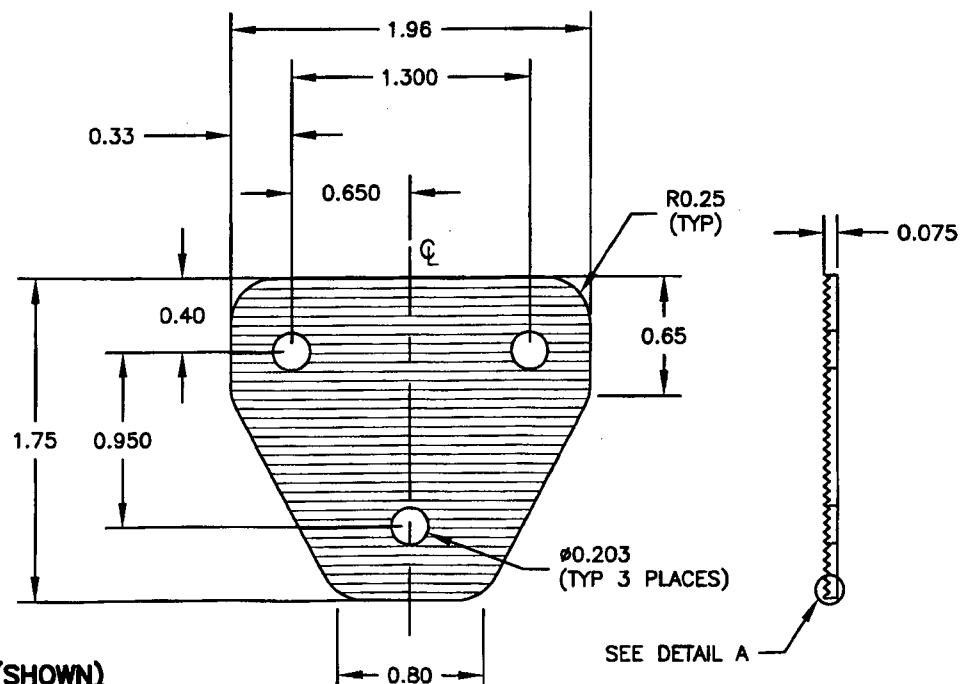
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED H	DRAWING NO. D3238
DATE 07.02.19		TITLE PLATE

REV. C  
SHEET 2 OF 3  
SCALE  
1:1

RELEASED

07.02.20

D3238-5 PLATE (SHOWN)  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



D3238-21 PLATE (SHOWN)  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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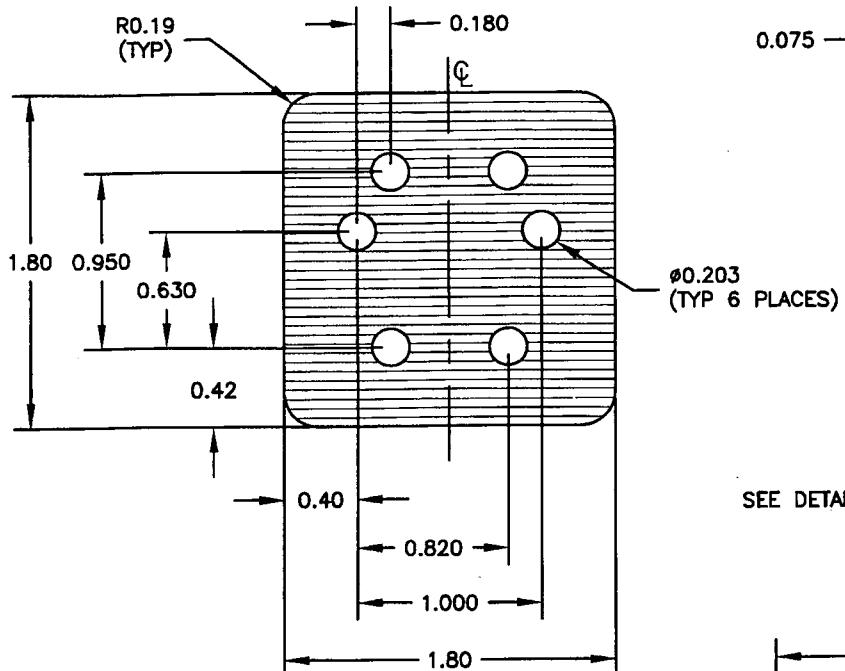
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DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

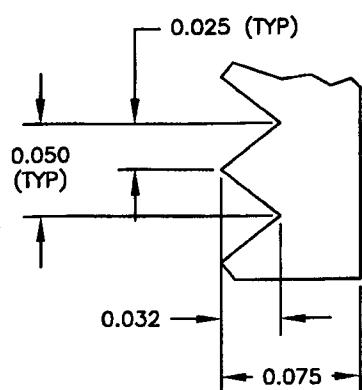


RELEASED

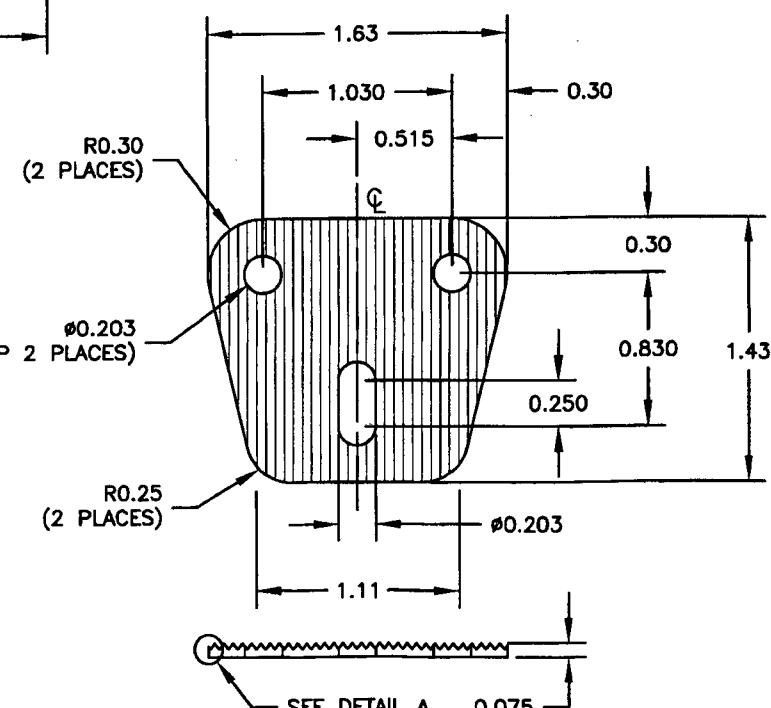
07.02.20

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

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